

Date: Monday, 4/10/2006 11:12:53 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 26599	
Estimate Number : 12246	
P.O. Number : N/A	Part Number : D3480041
This Issue : 4/10/2006 S.O. No. : N/A	Drawing Number : D3480 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 26181	Material : N/A
Written By : <u>See comment below</u>	Due Date : 4/28/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.04.10</u>	
Comment : est rev. A 02.07 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34805	EYEBALL ADAPTER FLANGE
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-5	Flange	B26696

SB 06/04/25 (10)

2.0	D34803	tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-3	Tube	B26600

SB 06/04/25 (10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot weld as per dwg D3480

2-Cut tube flush as per dwg D3480

3-Deburr

SB 06/04/25 (10)

4.0	QC571	WELD INSPECTION
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Comment: WELD INSPECTION

06.04.27 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:12:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 26599

Part Number: D3480041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Electro Chemically Polish weldment as per Dwg D3480

Ensure Certificate of Conformity is attached

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06.04.27 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/28 (10)

Job Completion



U 06.04.28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

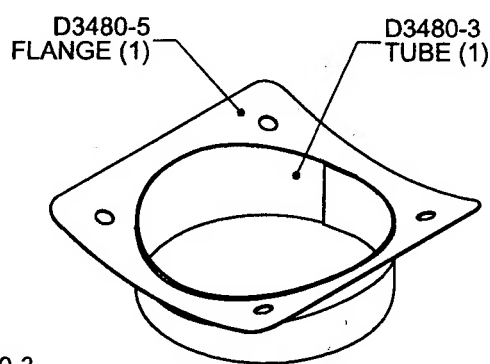
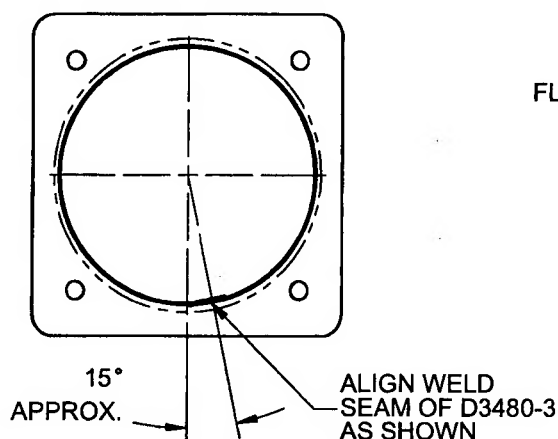
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

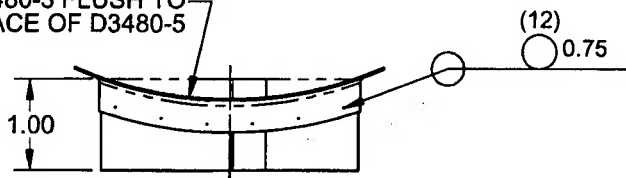


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3480	REV. A SHEET 1 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	

06.04.03



SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5



D3480-041 EYEBALL INLET ADAPTER

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WITHOUT NOTICE
WORK ORDER
NO. 26599

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

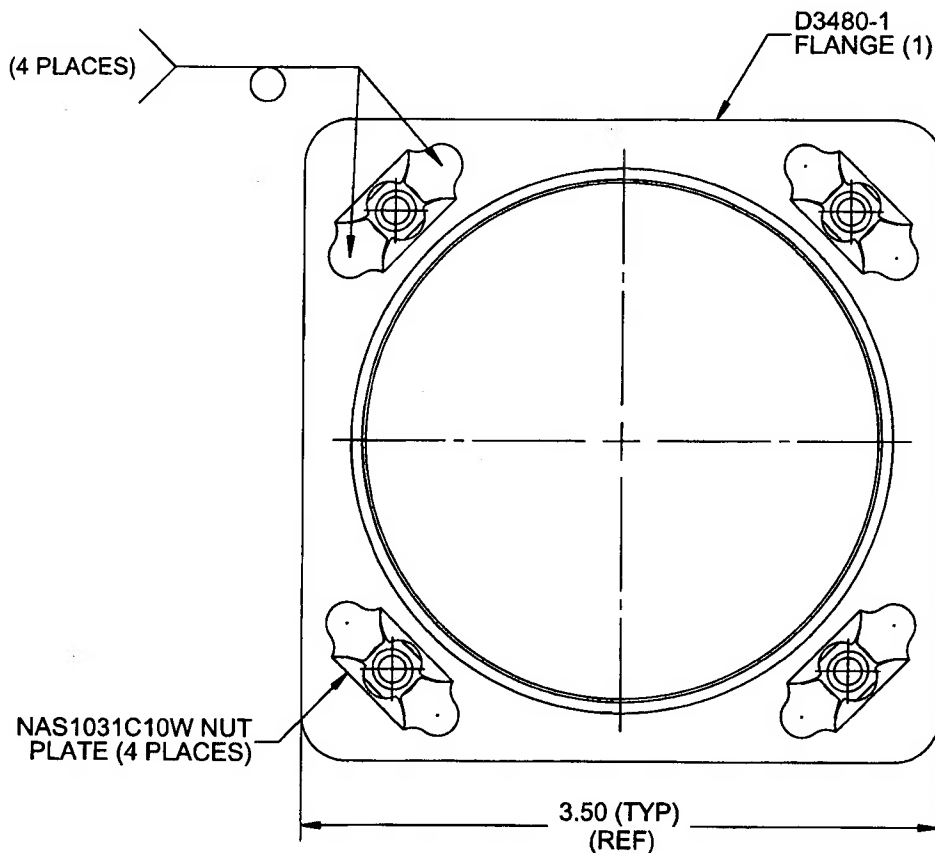
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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DATE 06.02.06		TITLE EYEBALL ADAPTER SCALE 1:1	



D3480-043 EYEBALL ADAPTER

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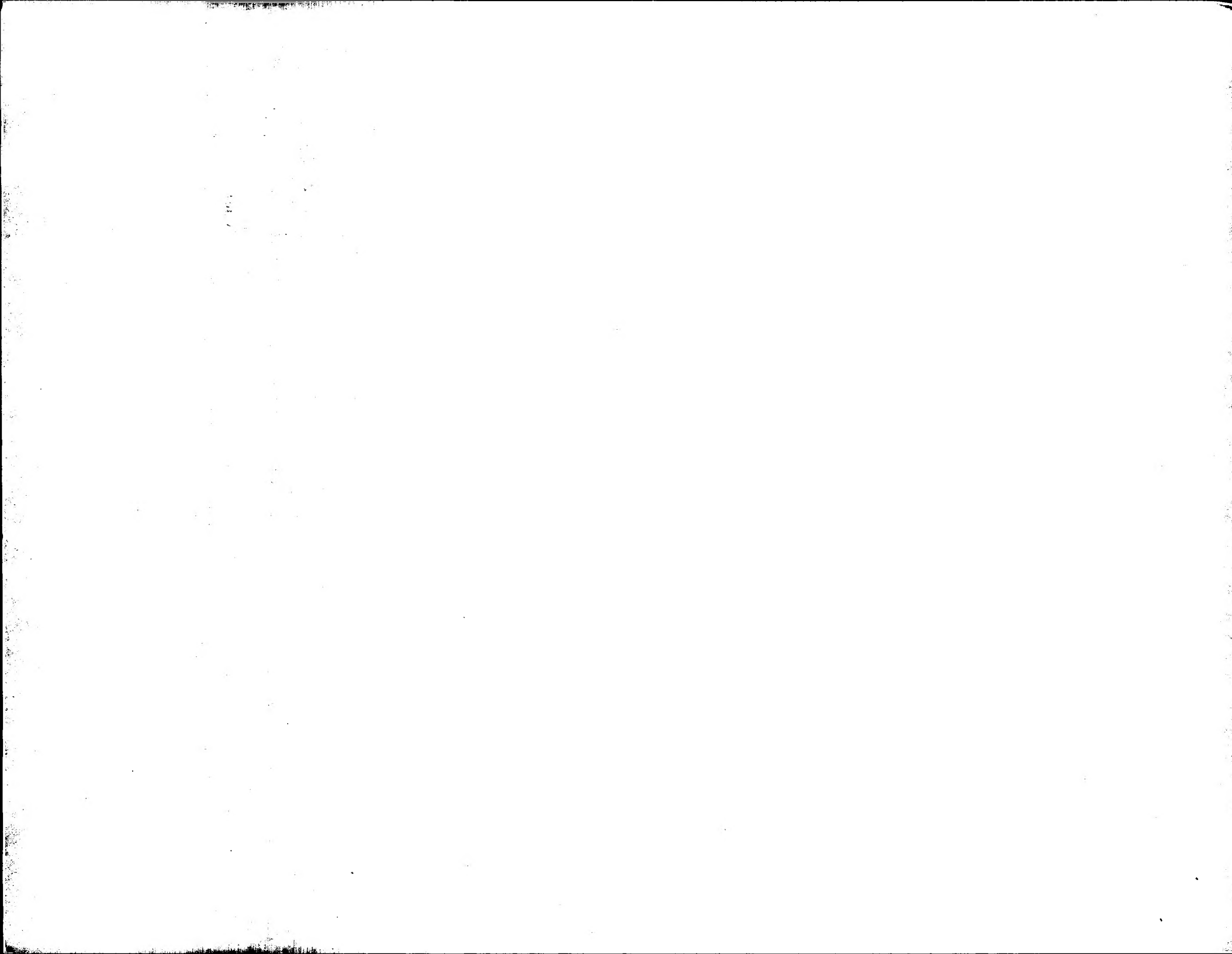
NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

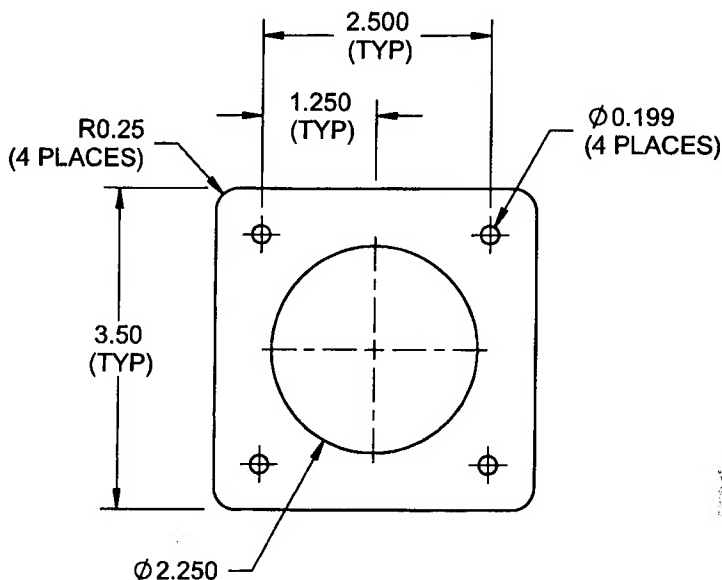
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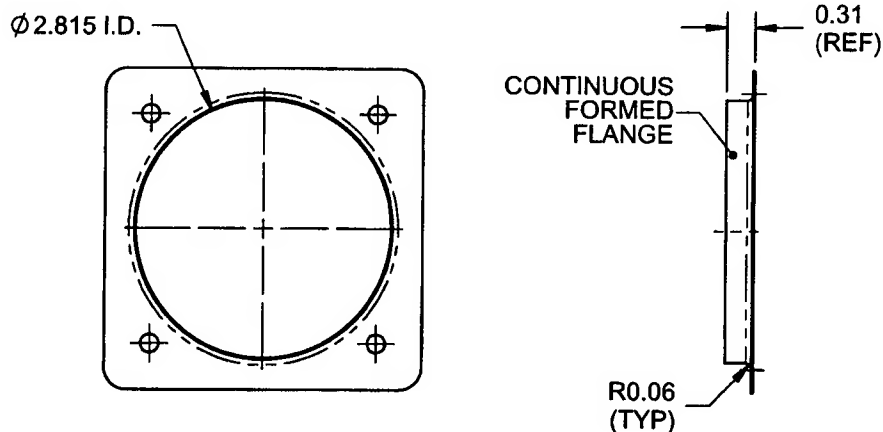


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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



[Handwritten: 06.04.03]

D3480-1F FLAT PATTERN



D3480-1 FLANGE (MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

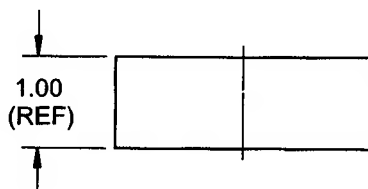
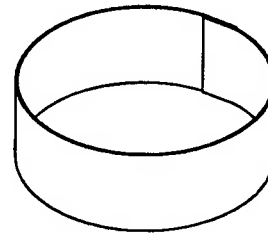
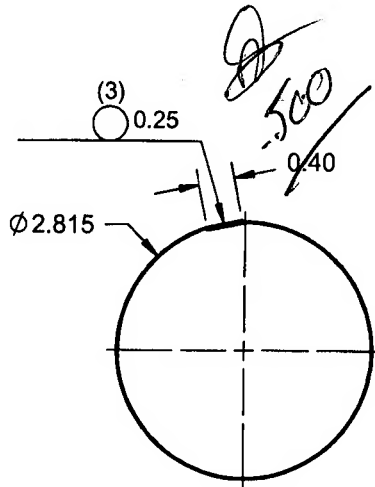
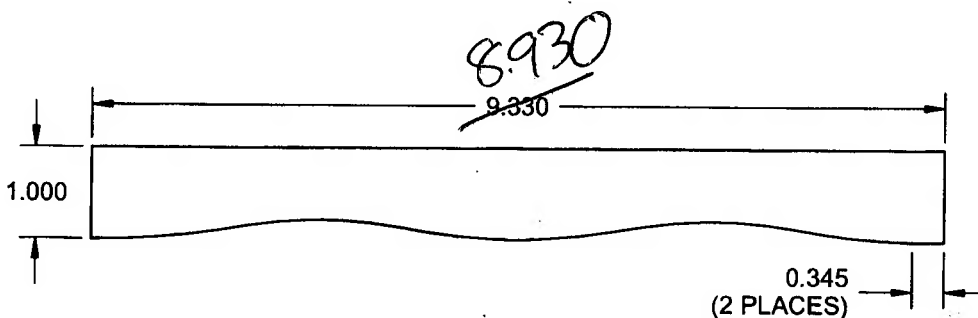
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2

**D3480-3 TUBE****D3480-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

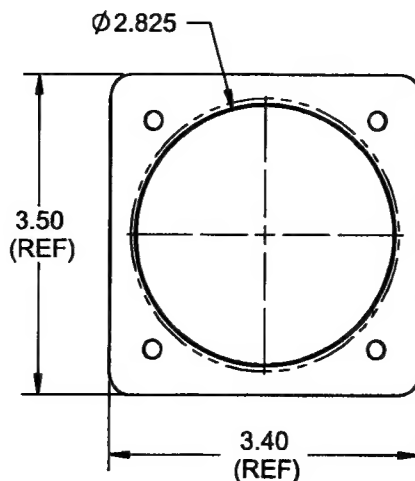
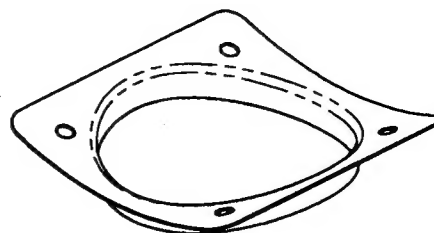
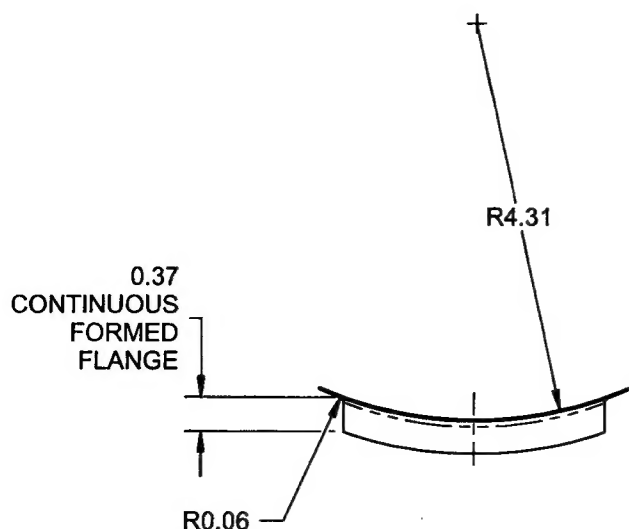
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



06.04.03

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

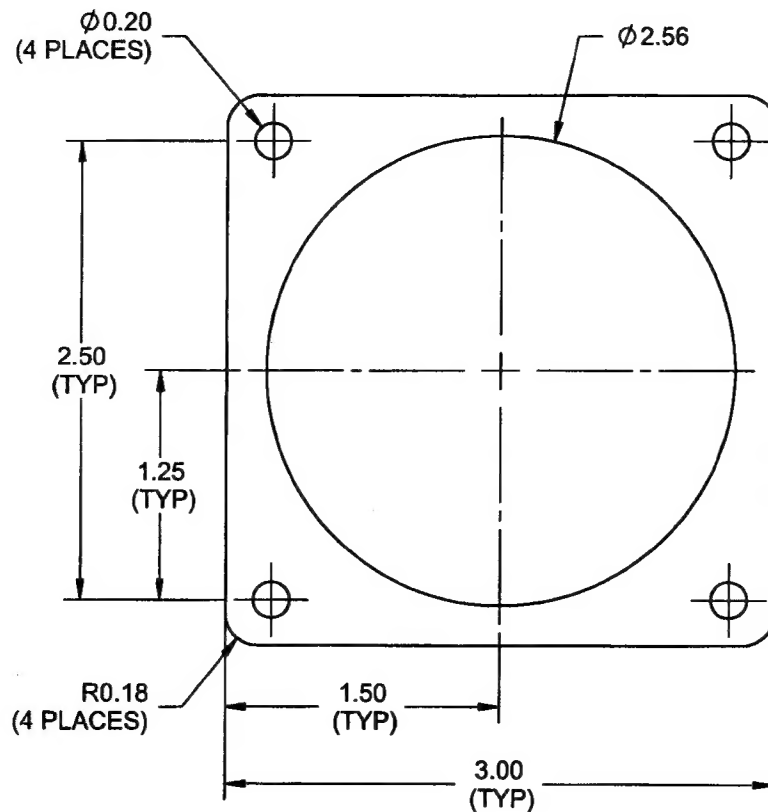
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:1



[Signature] 06.04.03

D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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